

Date: Monday, 6/19/2006 11:28:53 AM
 User: Kim Johnston

Process Sheet

| | | | |
|------------------------------------|--|---------------------------|----------------------------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | 212/205 HIGH AFT X-TUBE ASSEMBLY |
| Job Number : | 27629 | Part Number : | D212664201 |
| Estimate Number : | 10257 | Drawing Number : | D212-664-241 REV B |
| P.O. Number : | N/A | Project Number : | N/A |
| This Issue : | 6/19/2006 | Drawing Revision : | B |
| Prsht Rev. : | NC | Material : | N/A |
| First Issue : | N/A | Due Date : | 7/18/2006 |
| Previous Run : | 27628 | Qty: | 1 Um: Each |
| Written By : | <i>[Signature]</i> | | |
| Checked & Approved By : | <i>[Signature]</i> | | |
| Comment : | Est Rev: E 04.02.16 Reformat K/DS Est Rev: F 06-03-29 Remove Coments on Pick List JLM | | |

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D212-664-201CHG002

2.0

D6006129

Crosstube material



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6006-129 Crosstube 23970

Check OD = 3.250"; ID = 2.220"

3.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA114

2-Turn first side as per Folio FA114

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241. *[Signature]*

4.0

QC1

INSPECT ALL DIM TO DIM SHEET

Comment: INSPECT ALL DIM TO DIM SHEET *[Signature]*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|----------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | 10/10/00 | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/19/2006 11:28:53 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 27629

Part Number: D212664201

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA114

ml 06/07/04

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241.

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

ml 06/07/04

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/07/04 x 1

8.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Polish entire outside surface of crosstube

2-Remove sand and plugs

3-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-241

ml 06/07/04

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 within 24 hours of machining

RT 06-07-11

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

pm 06-07-17

11.0

BENDING

BENDING MACHINE


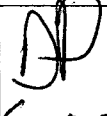


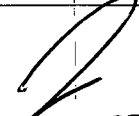


Comment: BENDING MACHINE

Bend tube as per Dwg D212-664-241 using CNC bender program 212-af and Folio FT007

DP 6-10-12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
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| | | | | | | | |

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| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| 06-10-23 | 11.0 | Tube was bent from angle. Does not fit table good at all. |  06/10/23 | Scrap & destroy. See Attached e-mail. |  6-10-23 |  06-10-23 |  06/10/23 |  06-10-23 |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

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Date: Monday, 6/19/2006 11:28:53 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001: Dart Helicopters Services

Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 27629

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D212-664-241 using drill Jig DT8550 & DT8551

2-Ream hole to finish size in tube as per Dwg D212-664-241 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 within 24 hours of bending and drilling

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

16.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038

Issue P/O: _____

LPI as per ASTM 1417 Level 2

Attach copy of NDT results to work order

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage Ensure copy of NDT results attached to work order.

18.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect for damage & ensure results are as per Dwg D212-664-241

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
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Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 27629

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

20.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

21.0

D2856600

Abrasion Strip



Comment: Qty.: 0.8400 f(s)/Unit Total : 0.8400 f(s)

Pick:

Qty Part number Description Batch

2 D2856-600-1009 Abrasion Strip

22.0

D29401

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2940-1 Support

23.0

MS2192028

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-28 Clamp

24.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8582

2-Install supports and clamps as per Dwg D212-664-241. Torque clamps to 80-100 in lb.

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 27629

Part Number: D212664201

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

25.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

27.0

D34281

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Placard

Batch: _____

28.0

AN640A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: _____

29.0

AN641A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: _____

30.0

AN960JD616

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Batch: _____

31.0

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Batch: _____

| W/O: | | WORK ORDER CHANGES | | | | | |
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 27629

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

33.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Identify and pack for shipping as per PPP D212-664-201

34.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



U Dell-03

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

| | | | |
|---|--|---------------------|--------------|
| DART AEROSPACE LTD | | Work Order: | 27629 |
| Description: Crosstube Assembly (205/212 High Aft) | | Part Number: | D212-664-241 |
| Inspection Dwg: D212-664-241 Rev: B | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

| | Inspection Sheet Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|--------|---------------------------------------|---------------|---------------------|--------|--------|-------------------------|----------|
| SIDE A | 0.200 | +/-0.010 | 0.205 | — | | | |
| | R0.063 | +/-0.010 | R0.063 | — | | | |
| | 2.990 | +0.005/-0.000 | 2.991 | — | | | |
| | 5.237 | +/-0.030 | 5.240 | — | | | |
| | 2.600 | +0.005/-0.000 | 2.601 | — | | | |
| | 2.686 | +0.005/-0.000 | 2.690 | — | | | |
| | 2.770 | +0.005/-0.000 | 2.774 | — | | | |
| | 2.854 | +0.005/-0.000 | 2.857 | — | | | |
| | 2.938 | +0.005/-0.000 | 2.942 | — | | | |
| | 3.021 | +0.005/-0.000 | 3.025 | — | | | |
| | 3.133 | +0.005/-0.000 | 3.135 | — | | | |
| | 3.179 | +0.005/-0.000 | 3.183 | — | | | |
| | | | | | | | |
| | | | | | | | |
| | | | | | | | |
| SIDE B | 0.200 | +/-0.010 | 0.205 | — | | | |
| | R0.063 | +/-0.010 | R0.063 | — | | | |
| | 2.990 | +0.005/-0.000 | 2.991 | — | | | |
| | 5.237 | +/-0.030 | 5.240 | — | | | |
| | 2.600 | +0.005/-0.000 | 2.603 | — | | | |
| | 2.686 | +0.005/-0.000 | 2.690 | — | | | |
| | 2.770 | +0.005/-0.000 | 2.774 | — | | | |
| | 2.854 | +0.005/-0.000 | 2.858 | — | | | |
| | 2.938 | +0.005/-0.000 | 2.941 | — | | | |
| | 3.021 | +0.005/-0.000 | 3.025 | — | | | |
| | 3.133 | +0.005/-0.000 | 3.135 | — | | | |
| | 3.179 | +0.005/-0.000 | 3.183 | — | | | |
| | 124.36 | +/-0.020 | 124.36 | — | | | |
| | | | | | | | |
| | | | | | | | |

| | | | | | |
|---------------------|----------|--------------------|----------|----------------------------|-----|
| Measured by: | JML | Audited by: | Ep | Prototype Approval: | N/A |
| Date: | 06/02/04 | Date: | 06/07/04 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------------|------------|----------|
| A | 05.04.27 | New Issue (P/O D412-664-201) | KJ/JLM | |
| B | 06.03.09 | Tolerance for 5.237 was +/-0.001 | KJ/JLM | |



| | | | |
|------------------------|-------------------------|--|------------------------|
| DESIGN PH | DRAWN BY PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D212-664-241 | REV. B SHEET 1 OF 3 |
| DATE 05.02.04 | | TITLE CROSSTUBE ASS'Y (205/212 HI AFT) NTS | |
| A | 00.12.12 | NEW ISSUE | |
| B | 05.02.04 | ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES | |

RELEASED
05.06.09 [Signature]

| Qty | Part Number | Description |
|-----|----------------|---------------------------------------|
| X | D212-664-241 | CROSSTUBE ASSEMBLY (205/212 HIGH AFT) |
| 1 | D6006-129 | CROSSTUBE |
| 2 | D2940-1 | SUPPORT |
| 2 | D2856-600-1009 | ABRASION STRIP |
| 4 | MS21920-28 | CLAMP |

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) MATERIAL: MANUFACTURED FROM D6006-129
FINISHED LENGTH = 124.36±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 5 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF SHOP COPY CROSSTUBE, CENTERED OPPOSITE D2940-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX 241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

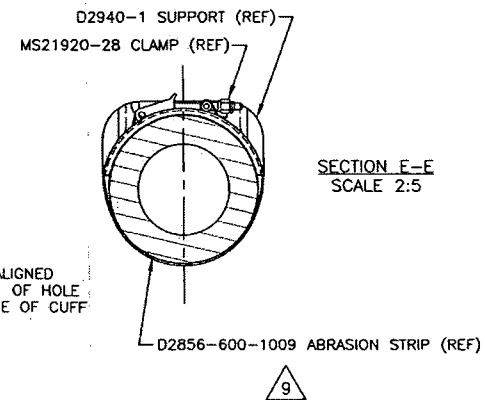
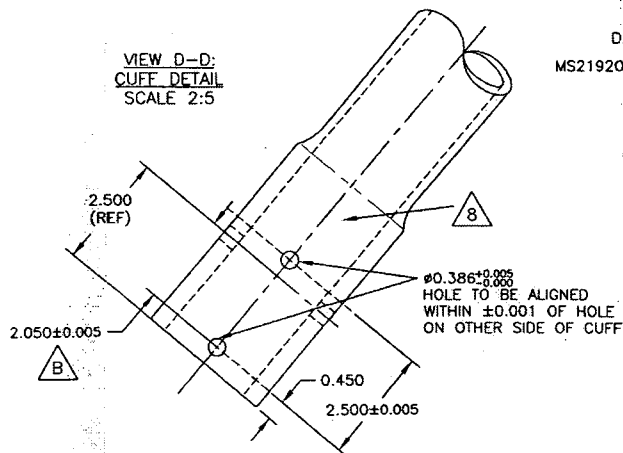
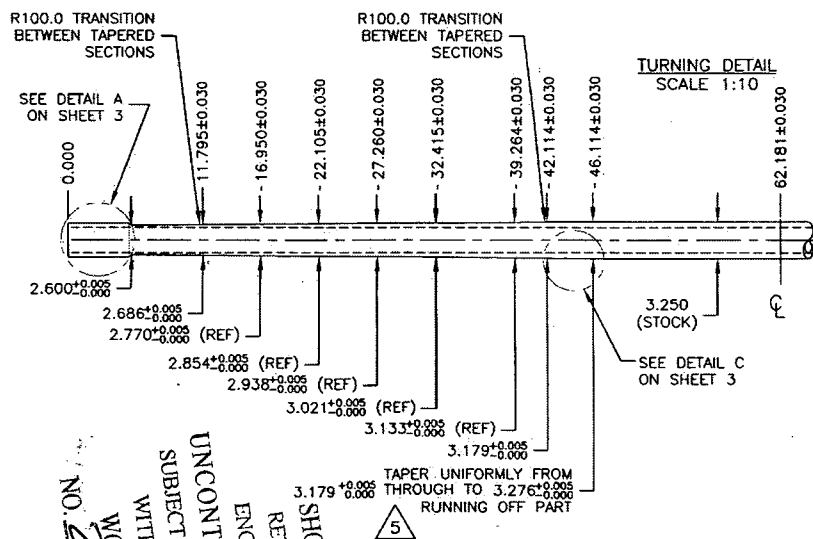
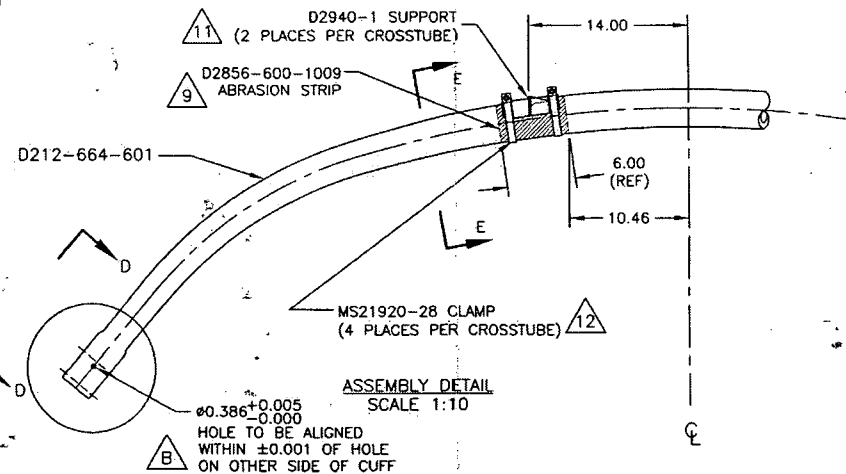
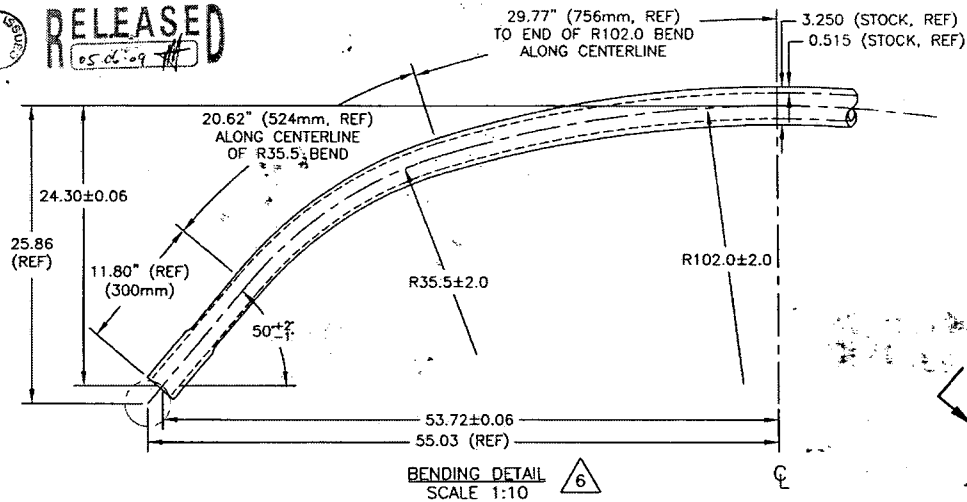
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27629

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RELEASED
05.02.04



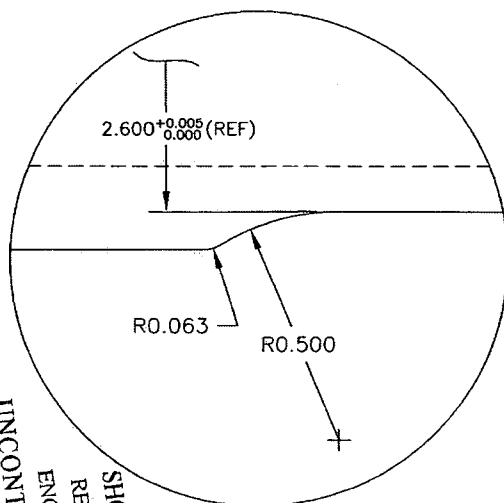
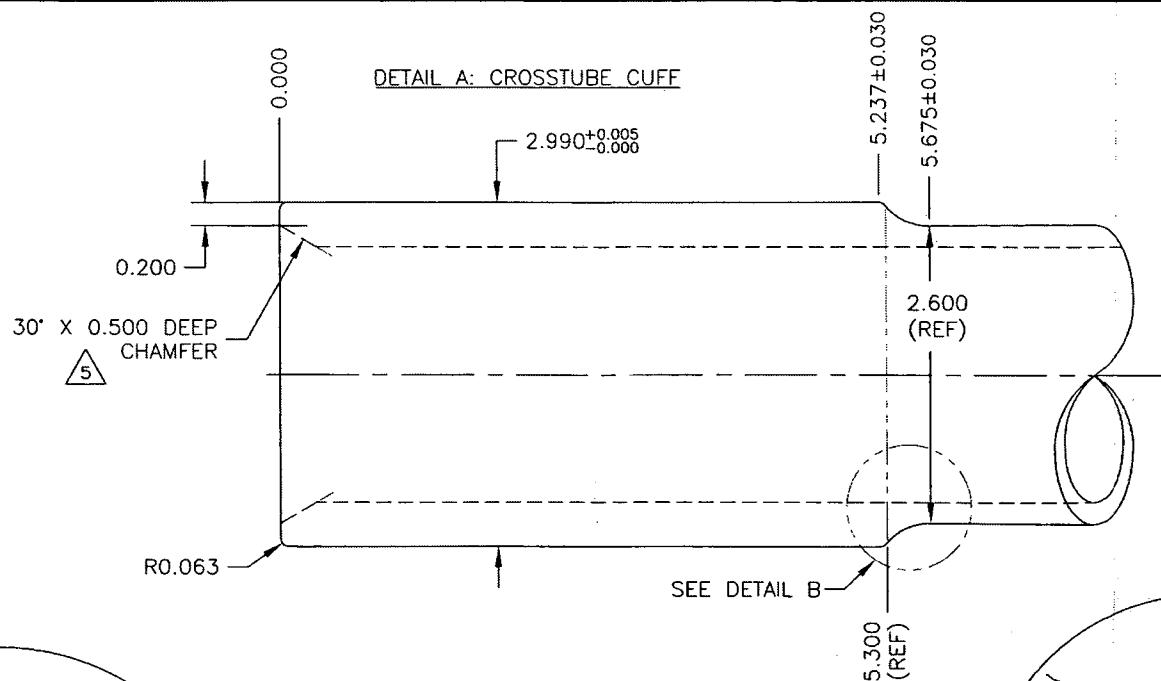
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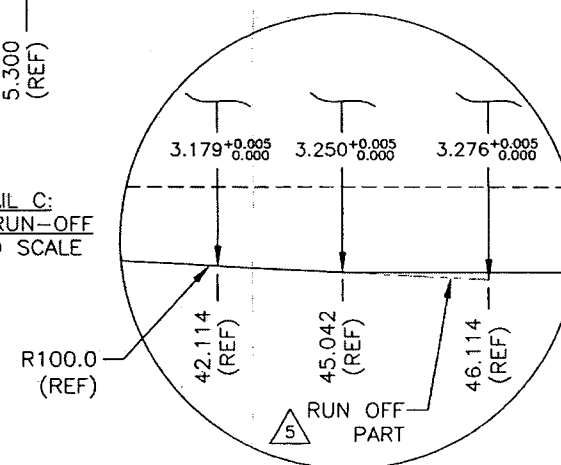
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|---------|----------|----------|----|----------------------------------|---|
| DESIGN | PH | DRAWN BY | PH | DART | DART AEROSPACE LTD. WARRICKSURY, OXFORD, GBR |
| CHECKED | PH | APPROVED | PH | DRAWING NO. | REV. B |
| | | | | D212-664-241 | SHEET 2 OF 3 |
| DATE | 05.02.04 | TITLE | | CROSSTUBE ASS'Y (205/212 HI AFT) | SCALE 1:10 |

NO. 27629
WORK ORDER
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
ENGINEERING
RETURN TO
SHOP COPY

RELEASED
05-06-09

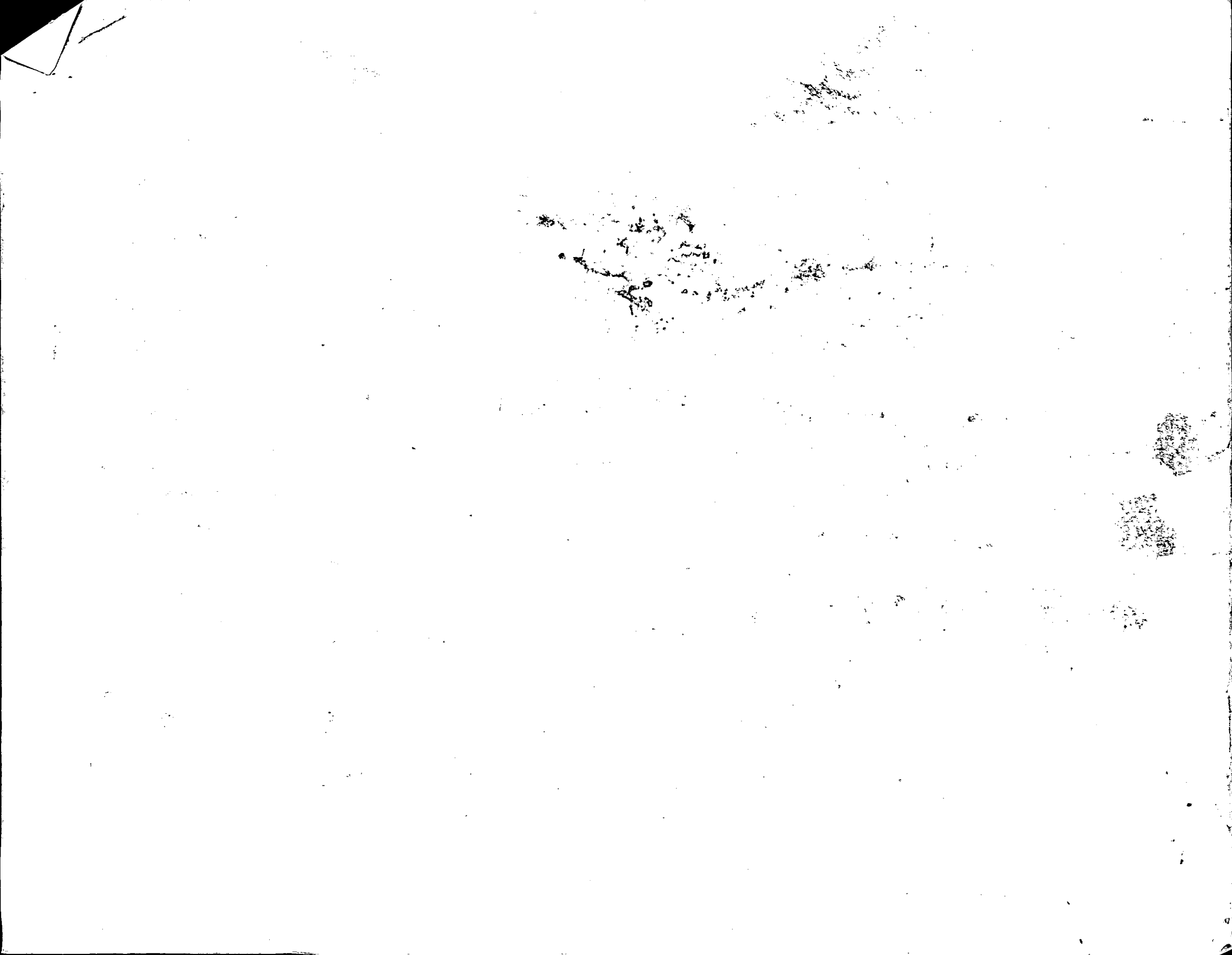


DETAIL C:
TAPER RUN-OFF
NOT TO SCALE



NO. 27629
WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
ENGINEERING
RETURN TO
SHOP COPY

| | | | | | |
|--|--|---|----------------|---|------------------------|
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| DATE 05.02.04 | | TITLE CROSSTUBE ASS'Y (205/212 HI AFT) | | SCALE 1:1 | |



Jason Murdoch

From: David Shepherd [dshepherd@dartaero.com]
Sent: Thursday, October 19, 2006 10:24 AM
To: 'Jason Murdoch'
Cc: 'L Lacelle'
Subject: RE: scan

Jason,

I don't like the large discrepancy in the angles (47.5 vs 50 degrees) or the funny shape.

I think we should scrap this tube.

Sorry for taking so long to get back to you.

David

From: Jason Murdoch [mailto:jmurdoch@dartaero.com]
Sent: Tuesday, October 17, 2006 11:58 AM
To: davids@dartaero.com
Subject: FW: scan

From: Jason Murdoch [mailto:jmurdoch@dartaero.com]
Sent: Monday, October 16, 2006 12:05 PM
To: davids@dartaero.com
Cc: Linda lacelle (llacelle@dartaero.com)
Subject: FW: scan

I don't really like the form of this tube or the jig fit at all. If we bring side 'B' in to dwg angle, it should fit the table better, but the center line will be moved over when the time comes to install the supports. What are your thoughts there Captain??

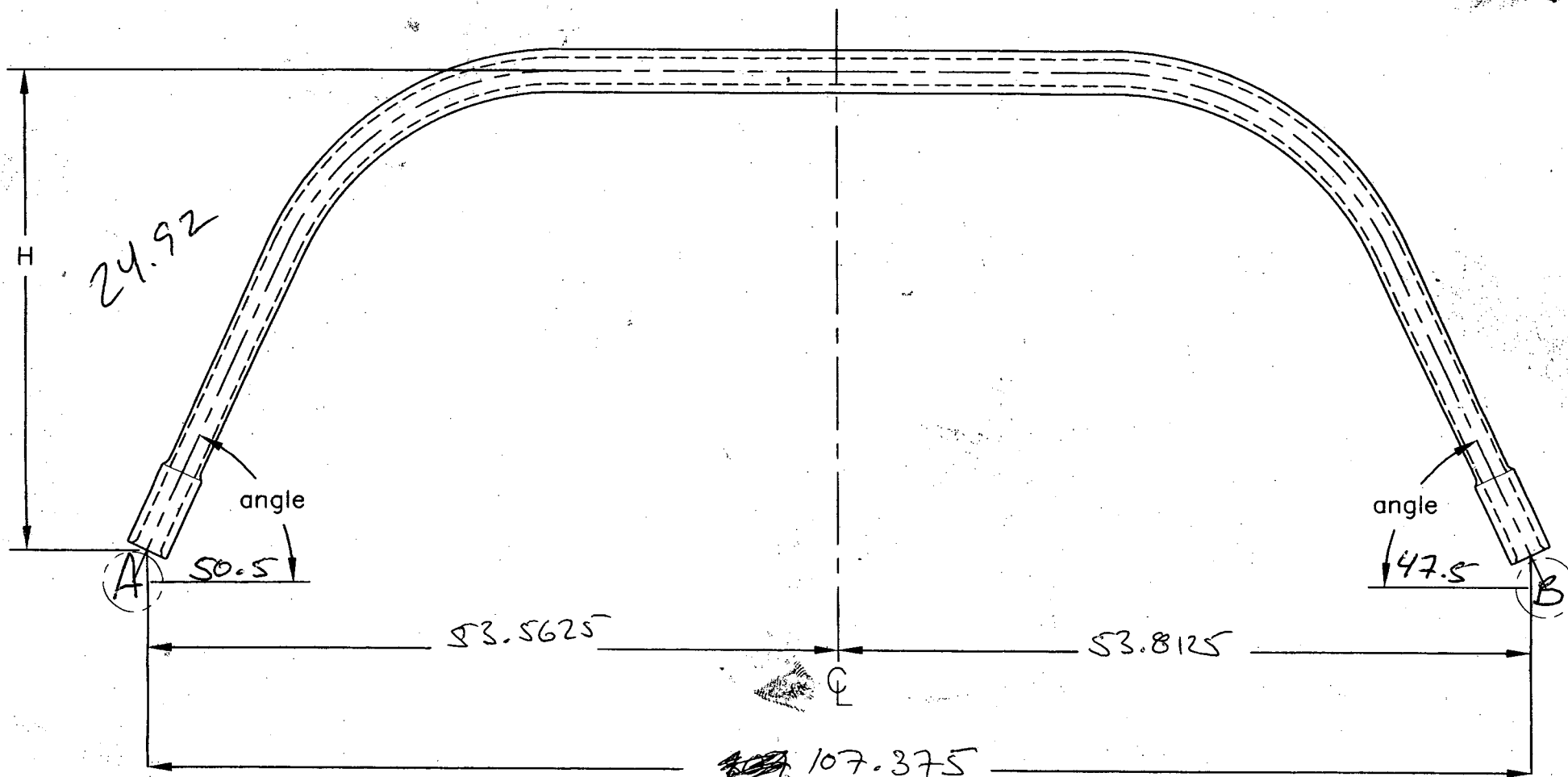
jmurdoch@dartaero.com

Q.C.Inspector

From: Brigitte Golden [mailto:bgolden@dartaero.com]
Sent: October 16, 2006 11:42 AM
To: jmurdoch@dartaero.com
Subject: scan

Brigitte Golden
Order Processing
Dart Aerospace Ltd.
bgolden@dartaero.com

10/19/2006



DATE: 06-10-16

DESCRIPTION: D212-664-241

BATCH NO: B27629

DRAWING: 212-664-241 Rev. B

H: 24.30 } $\pm .06$

1/2 SPAN: 53.72

TOTAL SPAN: 107.44

ANGLE: 50° $\frac{+3}{-1}$

Height is .62 over nominal. At side 'A', side 'B' is 24.625

Board layout is Ref. Only, but form doesn't match the board.

